

Date: Tuesday, 7/1/2008 2:35:04 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 40197		Part Number	: D2570		
Estimate Number	: 10175		Drawing Number	: D2570 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/1/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: MACHINED PARTS			
Previous Run	: 39805		Due Date	: 7/21/2008		
Written By	:		Qty:	300	Um:	Each
Checked & Approved By	:					
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material changeK J est F 07.07.06 rev B dwg EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75"
Comment: Qty.: 0.0810 f(s)/Unit Total : 24.2865 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>0108220</u> <span style="margin-left: 100px;"><u>M/N= 08/07/06</u></span> <span style="margin-left: 100px;">306</span>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Debur <span style="margin-left: 100px;"><u>M/N= 08/07/06</u></span> <span style="margin-left: 100px;">300</span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="margin-left: 100px;"><u>M/N= 08/07/06</u></span> <span style="margin-left: 100px;">300</span>		
4.0	QC8	SECOND CHECK <span style="margin-left: 100px;"><u>08/07/07</u></span> <span style="margin-left: 100px;"><u>QSP019</u></span> <span style="margin-left: 100px;">X300</span> <span style="margin-left: 100px;">counter</span>
Comment: SECOND CHECK <span style="margin-left: 100px;"><u>08/07/07</u></span> <span style="margin-left: 100px;">300</span>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>37</u> <span style="margin-left: 100px;"><u>8/7/7</u></span> <span style="margin-left: 100px;">50</span>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40197

Part Number: D2570

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 Lj

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 28-07-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<u>40197</u>
<b>Description:</b> Bushing	<b>Part Number:</b>	<u>D2570</u>
<b>Inspection Dwg:</b> D2570 <b>Rev:</b> B		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

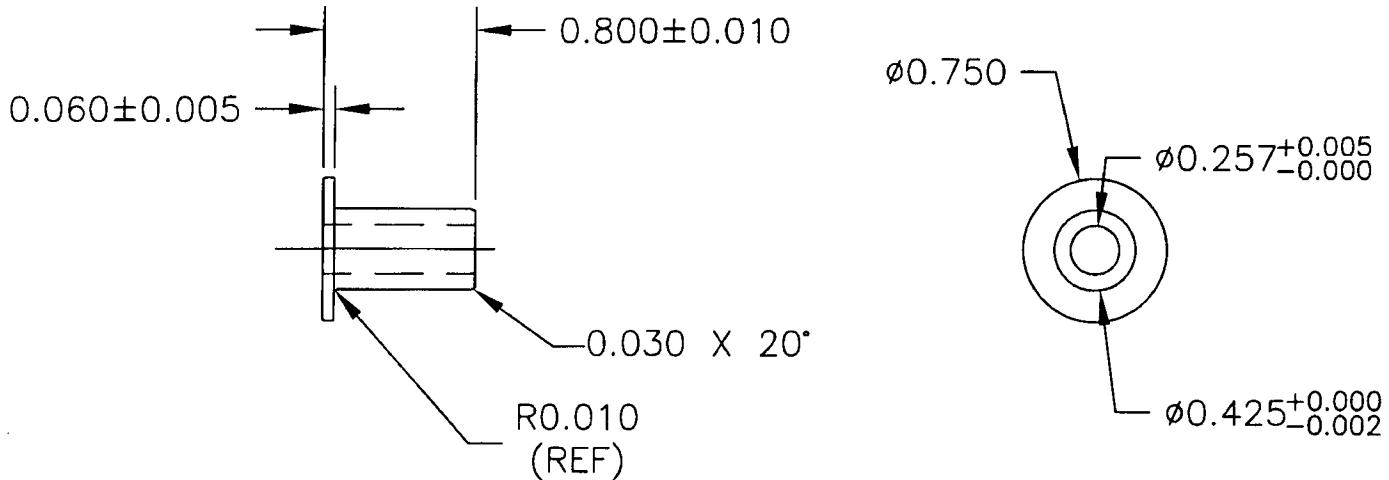
Measured by: <u>MM-J/KW</u>	Audited by: <u>DJP</u>	Prototype Approval: <u>N/A</u>
Date: <u>08/07/06</u>	Date: <u>08/07/06</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	JK BE

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**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B	SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE	1:1
A	96.09.16	NEW ISSUE		
B	07.04.17	UPDATE NOTES		

**RELEASED**  
07.06.28 *PH***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40197

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